



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-300
Job Sheet 178639



Part No: SWA10A-300

Job Qty: 20 ea

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A-300 Rev 5 IPP Rev A 17.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		6/22/18	0.00	0.00	Start Up Machining-3		IL
100	Bandsaw	20 pcs		6/22/18	0.00	2.00	Bandsaw1		IL
110	Mori Seiki	20 pcs		6/22/18	0.00	20.00	MORI NLX		IL
120	QC	20 pcs		6/22/18	0.00	0.00	QC2		IL
130	QC	20 pcs		6/22/18	0.00	0.00	QC8		IL
140	Packaging	20 pcs		6/22/18	0.00	0.00	Packaging3		IL
150	QC21-SA	20 Ea		6/22/18	0.00	0.00	QC21		IL

Part Op 100 - Cut Blanks to 3.560"

Descriptions: 110 - 1-Machine as per DWG. FB711 FOLIO REV: AA DWG REV: 5 2-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R4.000	17-4 SS H1150 Round Bar 4.000"	6 ft (.3 ea)	90-Start up Operation	SC42021:3.0

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R4.000	6	6	0

Part Specifications

Specifications could not be found.

Plex 6/5/18 11:29 AM Dart.lajeunesse.marie



Container No: S098673



Part: SWA10A-300

Job No: 178639

Serial No/Batch: S098673

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/02/18

DART AEROSPACE LTD		Work Order:	178639
Description: Bearing Housing		Part Number:	SWA104-300
Inspection Dwg: SWA104-300	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.710	±.0016	3.705			Mic 112-127	
Ø 3.505	+0.000/-0.002	3.505			Mic 104-137	
3/2 - (6 UN) 1B	GO/NOGO	GO				
.04 x 45°	±.01 x .5°	.04 x 45°				
1.235	±.003/-0.000	1.235			HG	
1.020	±.005	1.018				
.245	±.005	.244				
1.017	±.005	1.019				
.095	±.005	.094				
.03 x 45°	±.01 x .5°	.030 x 45°				
.02 x 45°	±.01 x .5°	.020 x 45°				
Ø 2.165	±.001	2.165			Mic LPO3	
Ø 2.3520/2.3521		2.3520				
Ø 3.071	+0.005/-0.000	3.0725				
Ø 3.120	±.005	3.120				
Ø 3.52	±.01	3.525				
.120	+0.005/-0.000	.121				
Ø 3.950	±.005	3.950				
3.430	±.005	3.429			HG	
.680	±.005	.682			Vern LPO9	
Ø 2.70	±.01	2.700				
.04 x 45°	±.01 x .5°	.042 x 45°				
.07 x 45°	±.01 x .5°	.07 x 45°				
.25	±.01	.25			Rad gage	

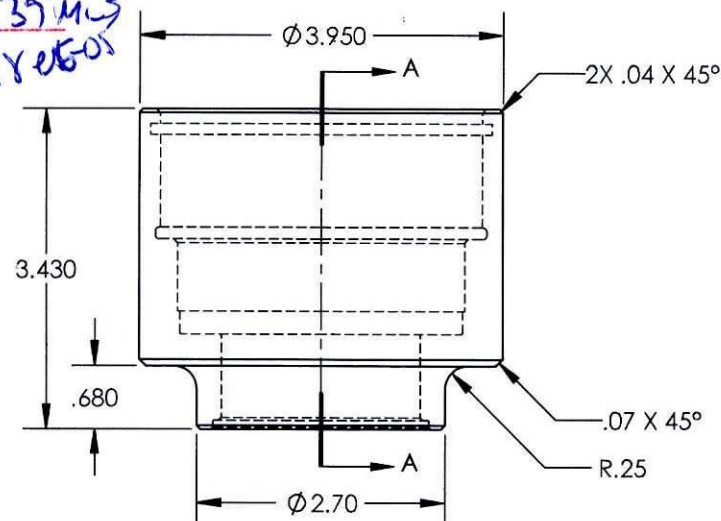
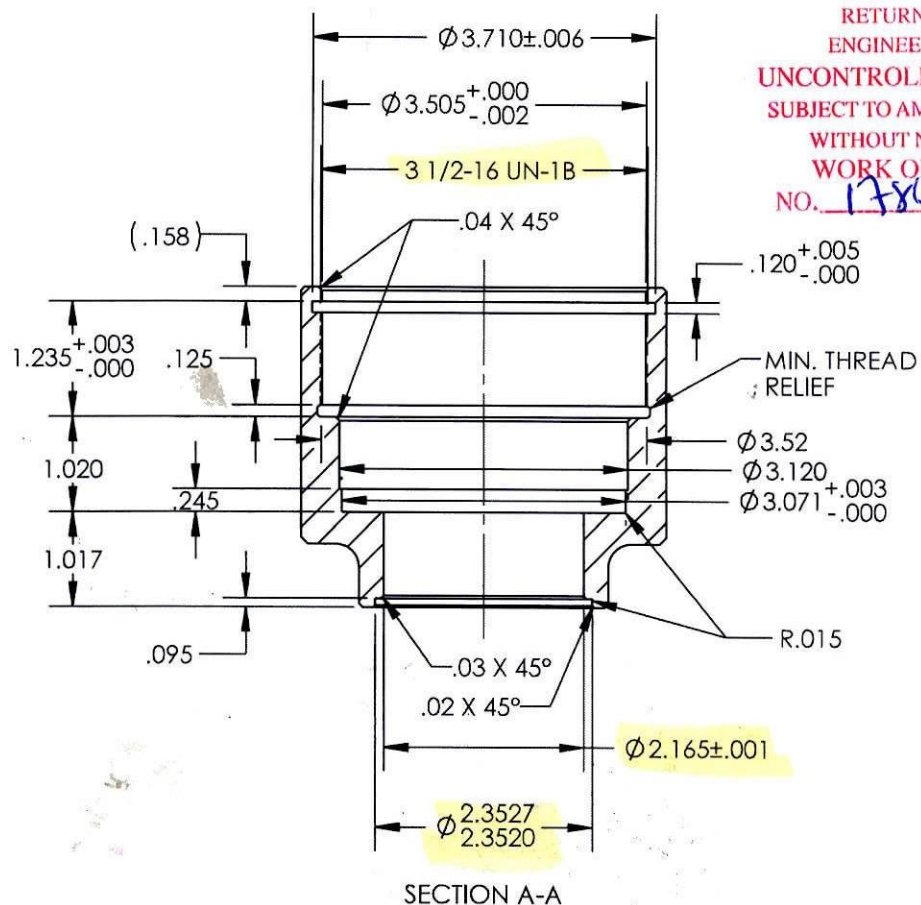
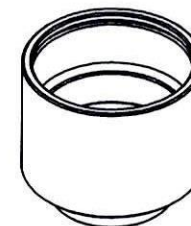
Measured by:	/s/	Checked by:	BA	QC Inspector:	
Date:	18-8-2	Date:	18-08-03	Date:	

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	11/12/2012	JAG	
3		CH'D TOLERANCE OF Ø2.352+0.003/-0.000 TO A LIMIT DIM.	11/16/2012	JAG	
4	15-0304	UPDATED TO NEW DRAFTING STANDARDS. ADDED MAT'L OPTION H1075.	10/16/2015	DPD	JAG
5	16-0252	CH'D THREAD DIM WAS 3-1/2-16 UN-2B IS 3-1/2-16 UN-1B, ADDED MIN. THREAD RELIEF NOTE.	12/5/2016	RJC	JAG

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178639 M.



.123

			
TITLE			
BEARING HOUSING			
DWG NO.			REV
SWA10A-300			5
MAT'L SS 17-4 H1150/H1075		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT FINISH		.XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125/✓	
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY: CANAM		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED: MACKOVJAK		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR: ANDERSON		USED ON MODEL	
QA APPR: LINDSAY			
APPROVED: GILBERT			
SCALE	1:2	DATE	2/21/2002
		SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	